

Work Order ID 67594

Page 1

Monday, March 28, 2011 11:51:09 AM

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10328

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

Deburr if necessary

304 - 040

B11-4-5

(13)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-5

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8404105

(x13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67594

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Page 2

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Revision ID:

Stop



Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	NC BRAKE					(13)			
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23			SB 11/6/06					
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00		8/10/06		(713)			
Quality Control									
150		0.00							
	Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:20 FINISH TIME: 1:50					13	BL	11-4-6	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Page 3

Item ID: D3535-23

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Revision ID:

Stop

Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 4 M 11/04/07

170

Identify as per dwg & Stock Location: FR-21

0.00



Packaging

Memo

0.00

Packaging

13 BK 11-4-7

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/7

M 11-04-7
(13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Monday, March 28, 2011 11:51:15 AM

Page 1

Work Order ID: 67594



Parent Item: D3535-23



Parent Item Name: Wearshoe


Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	109.0000	1.3615	17.19789			



KB 11-4-5

Location

Loc Qty

Loc Code

MAT020

109

115953

1

116437

44

116623

64

116023

13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67594
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	✓		V HB02	
2.000	+/-0.010	2.002	✓		V	
4.750	+/-0.010	4.750	✓		T HB02	
9.500	+/-0.010	9.500	✓		T	
14.250	+/-0.010	14.250	✓		T	
17.750	+/-0.010	17.750	✓		T	
23.140	+/-0.010	23.140	✓		T	
28.530	+/-0.010	28.530	✓		T	
33.920	+/-0.010	33.920	✓		T	
39.310	+/-0.010	39.310	✓		T	
44.700	+/-0.010	44.700	✓		T	
48.200	+/-0.010	48.200	✓		T	
52.850	+/-0.010	52.850	✓		T	
Ø0.188	+0.005/-0.001	.189	✓		V	
48.00	+/-0.030	48.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.305	✓		V	
0.038	+/-0.010	.038	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-4-15	Date: 11/04/15	Date:	N/A

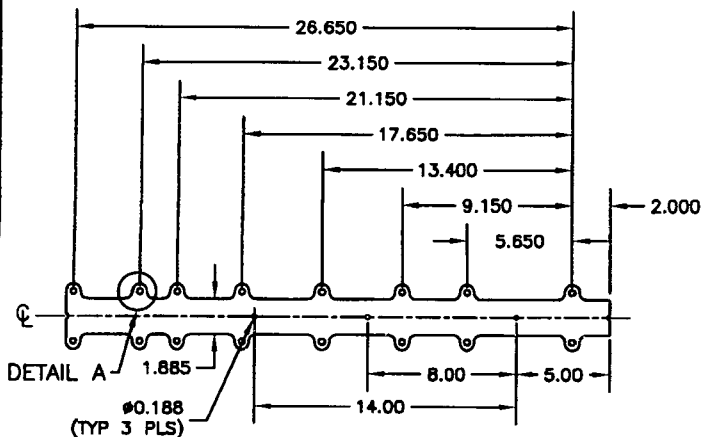
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	AS

DART

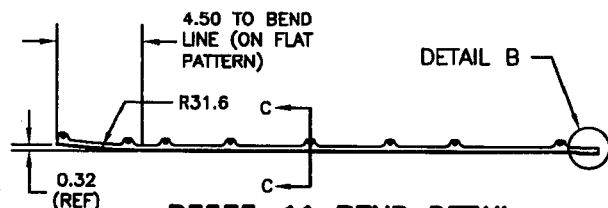
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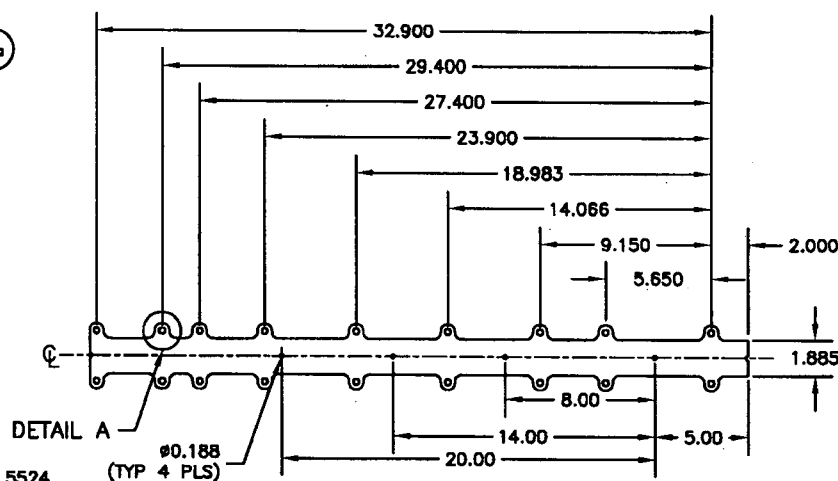
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47594
11-03-21



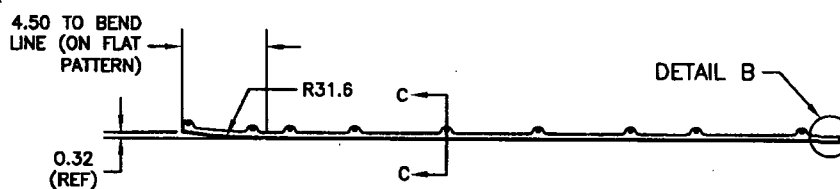
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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CB	PH	PORT HADLOCK, WA
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<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

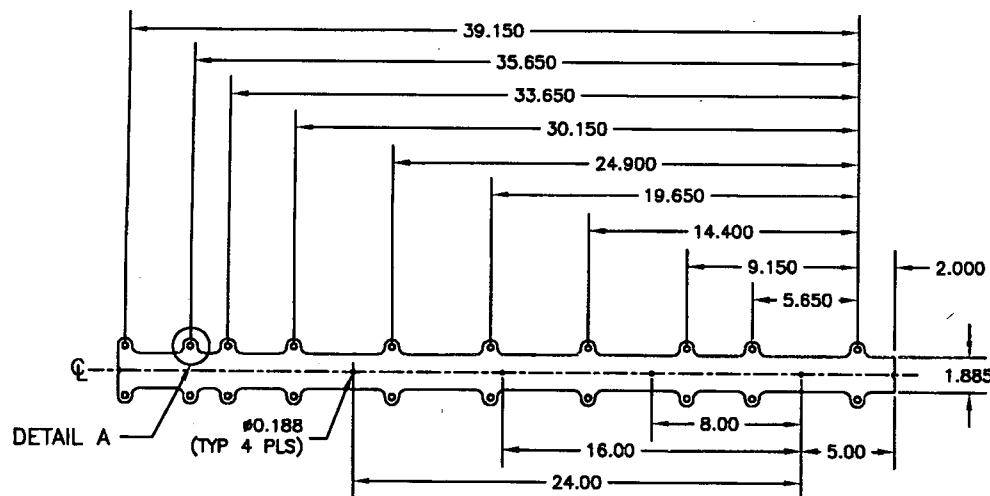
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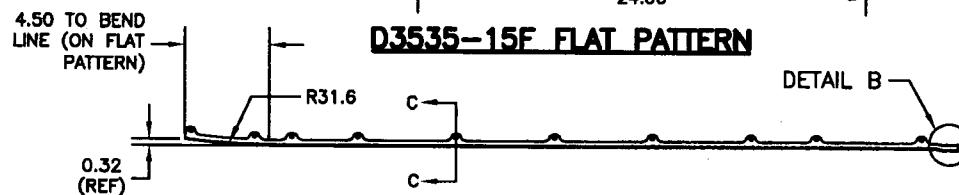
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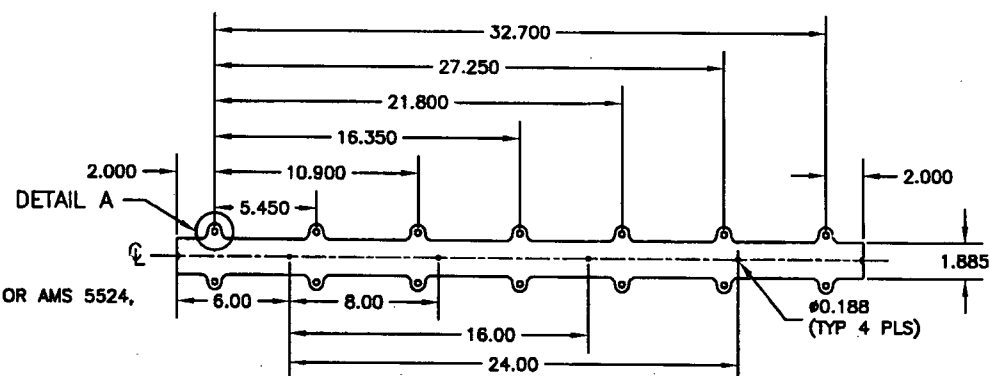
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		D3535	SHEET 2 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



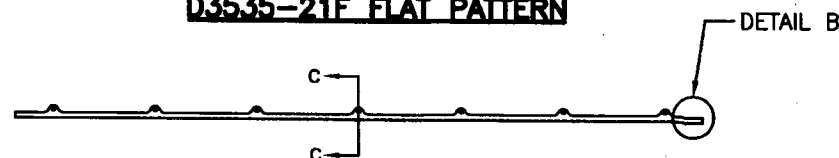
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

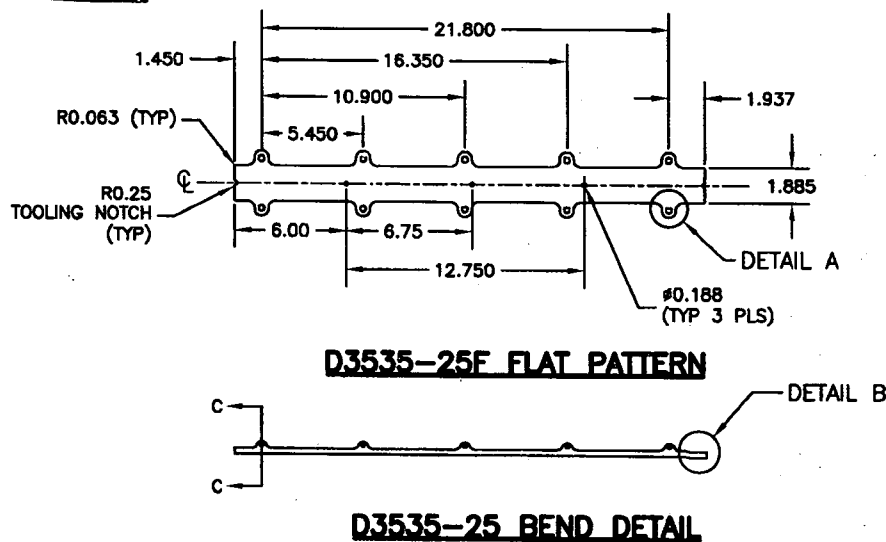
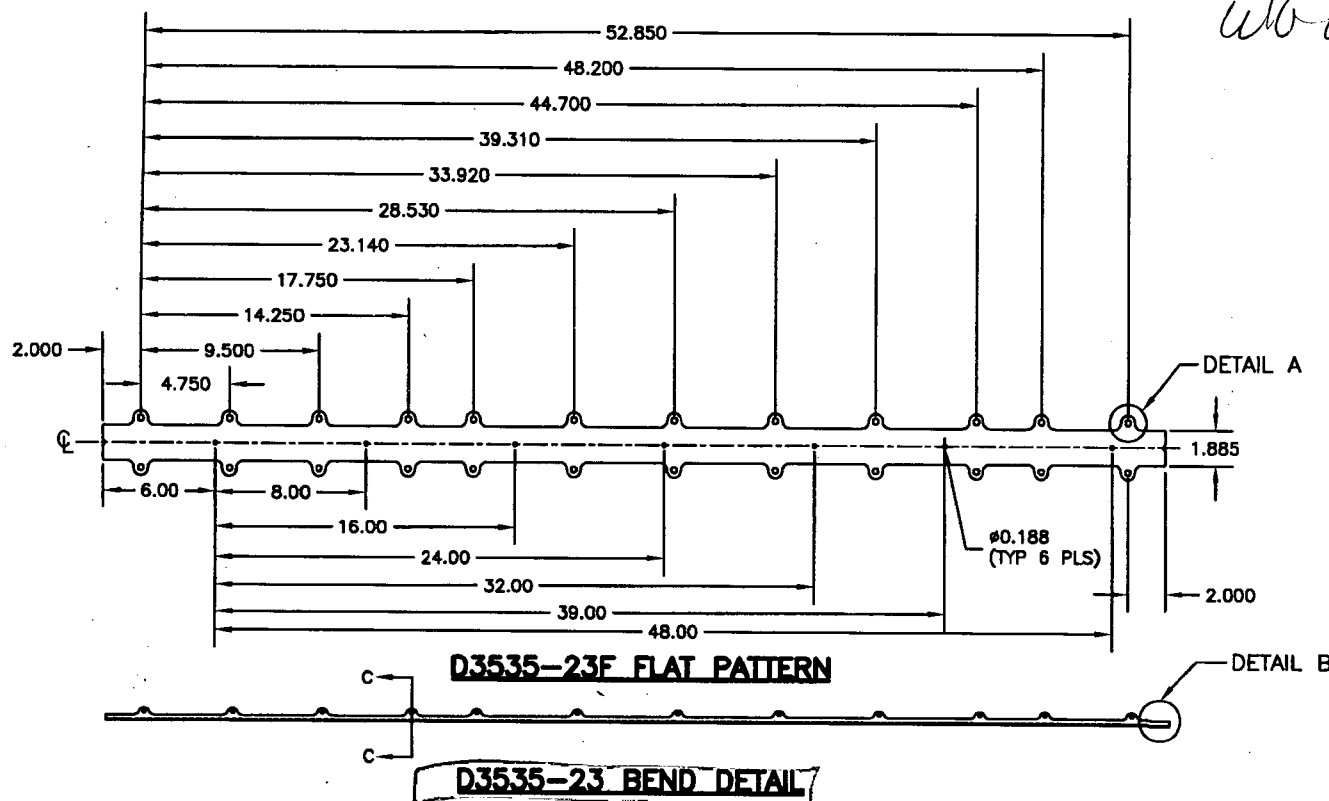
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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07.04.24

u/b 67594



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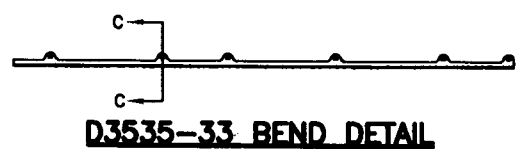
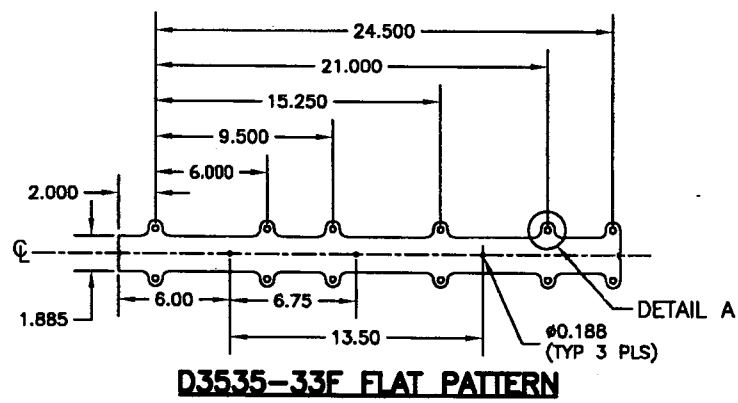
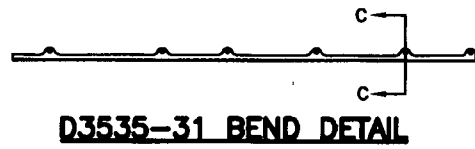
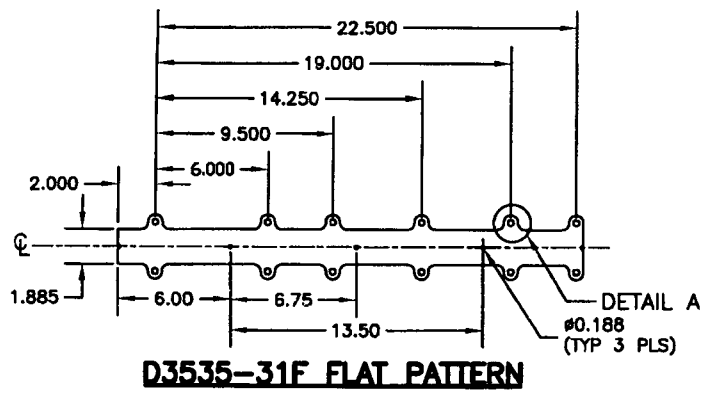
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		D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10



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07.04.24

W667594



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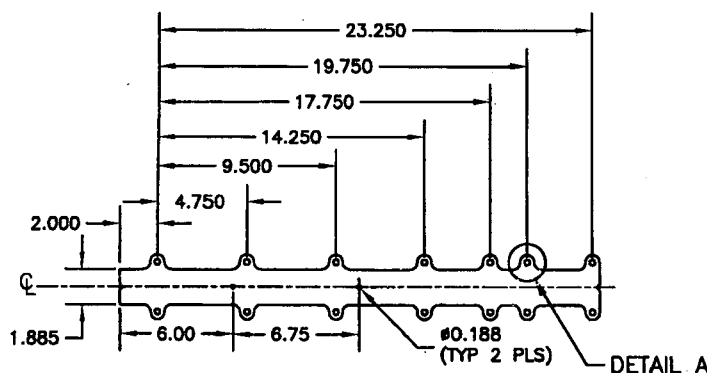
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		TITLE	WEARSHOE	SHEET 4 OF 7
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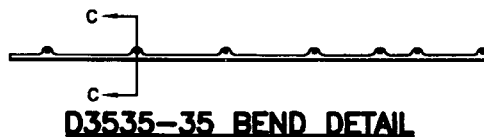
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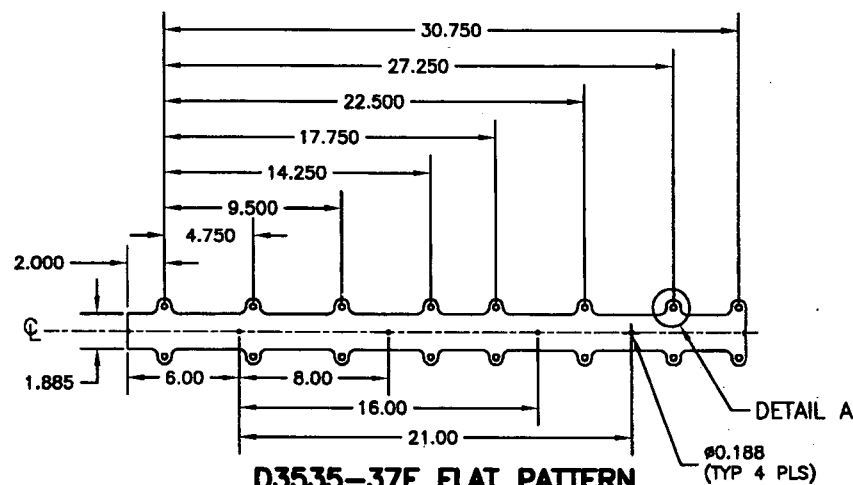
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

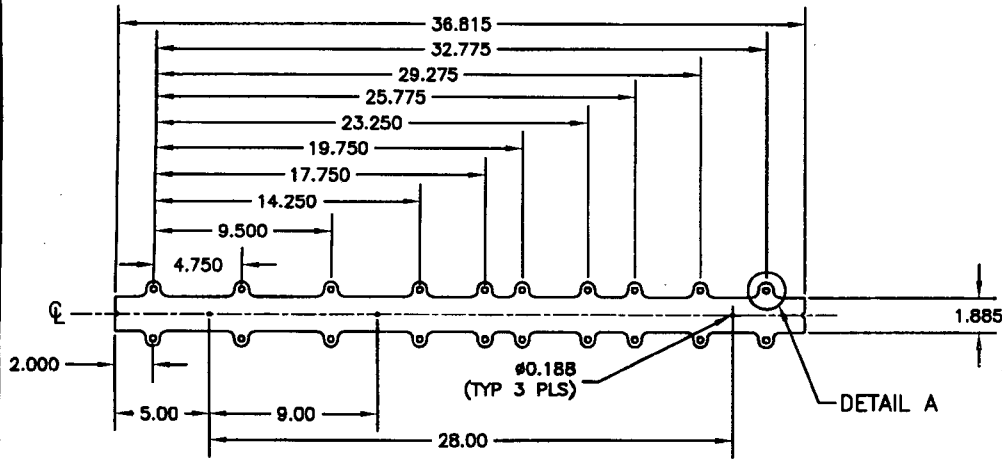
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			WEARSHOE	B
				SHEET 5 OF 7
				SCALE
				1:10

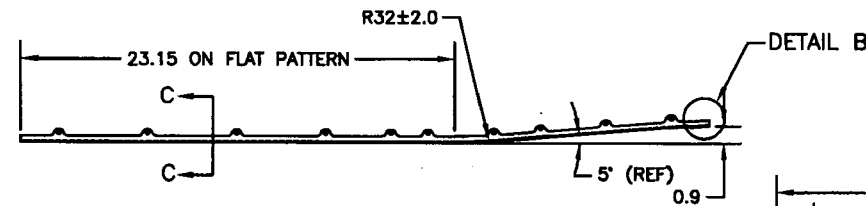
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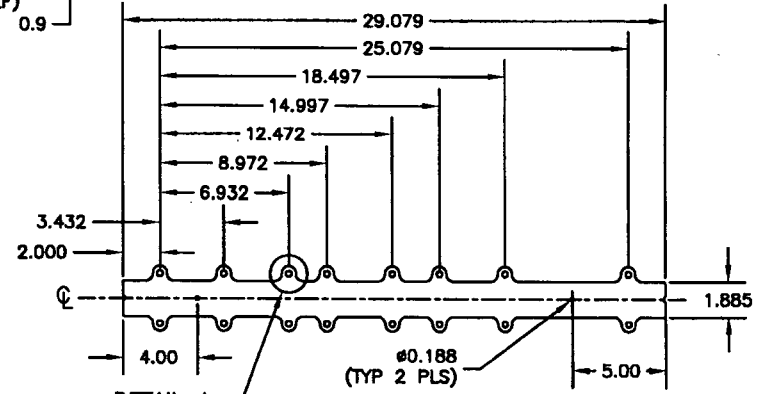
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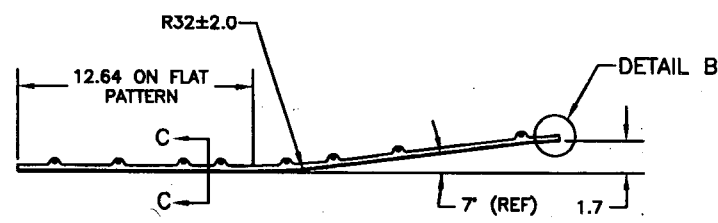
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

- NOTES**
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		D3535
DATE	TITLE	SHEET 6 OF 7
07.04.17	WEARSHOE	REV. B
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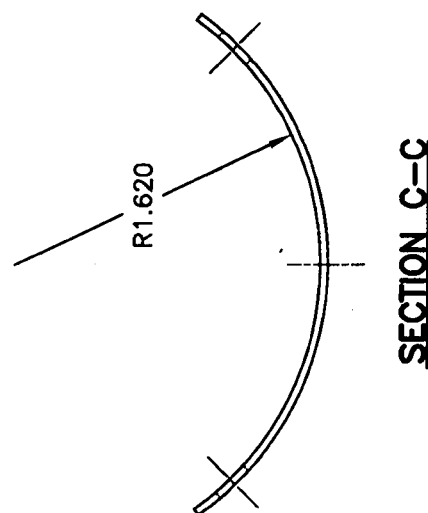
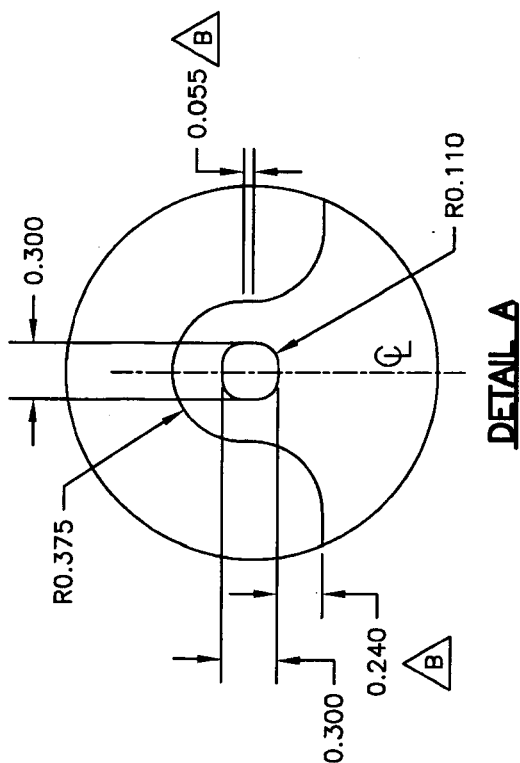
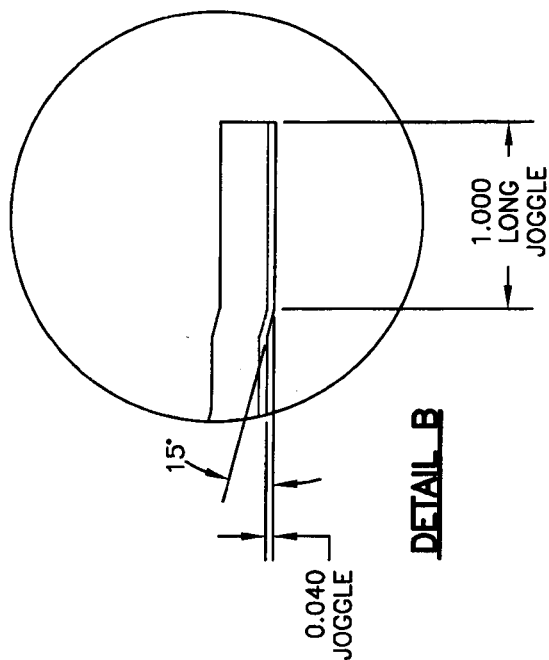


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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

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07.04.24

W/O C-7594



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